

1652



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RBE350A94-2706-00-03A

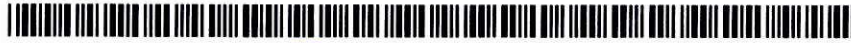
Job Sheet 173906

SNIP
S-17

Part No: RBE350A94-2706-00-03A

Job Qty: 18 ea

Part Name: Pin Shaft



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-15 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea		4/13/18	0.00	0.00	Start Up Machining-3		18-6-20
110	CNC Lathe	18 pcs		4/16/18	0.00	9.00	MORI SL-154		2.75
120	QC	18 pcs		4/16/18	0.00	0.00	QC2 Machining-4		
130	QC	18 pcs		4/16/18	0.00	0.00	QC8 Machining-4		18-06-21
140	Packaging	18 pcs		4/16/18	0.00	0.00	Packaging3-1		21 JUN 20 2018
150	QC21-SA	18 Ea		4/16/18	0.00	0.00	QC21		GA14

Part Op 110 - 1-Machine as per DWG. FB735 FOLIO REV: AA DWG REV: 6
Descriptions: number Using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
88625K67	Dowel Pin Ø8mm x 40mm	18 ft (1 ea)	90-Start up Operation	5050746-9

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	88625K67	18	59	0

Part Specifications

Specifications could not be found.

Plex 4/12/18 2:15 PM dart.logan.david



Container No: S082715



Part: RBE350A94-2706-00-03A

Job No: 173906

Serial No/Batch: S082715

Revision: 6

Inspector:

Exp Date:

Instructions:

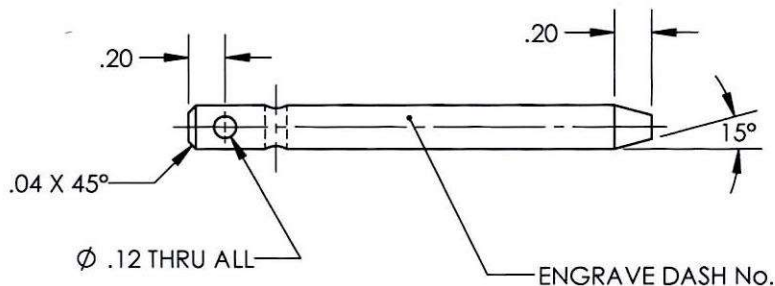
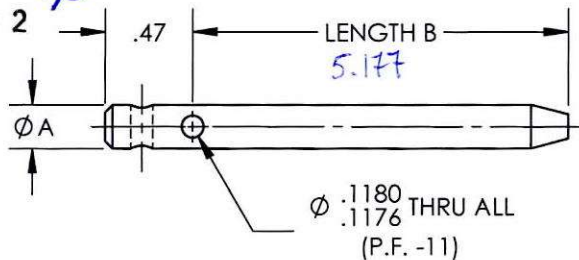
Date: 06/20/18

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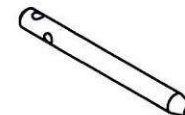
20180502



-01A, -03A, -05A, -07A, -09A

PIN SHAFT

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -01 THRU -09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	5/26/2015	RJC	RW
4	15-0120	CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005.	5/26/2015	DPD	JAG
6	16-0281	-01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 +.001/-0.000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG

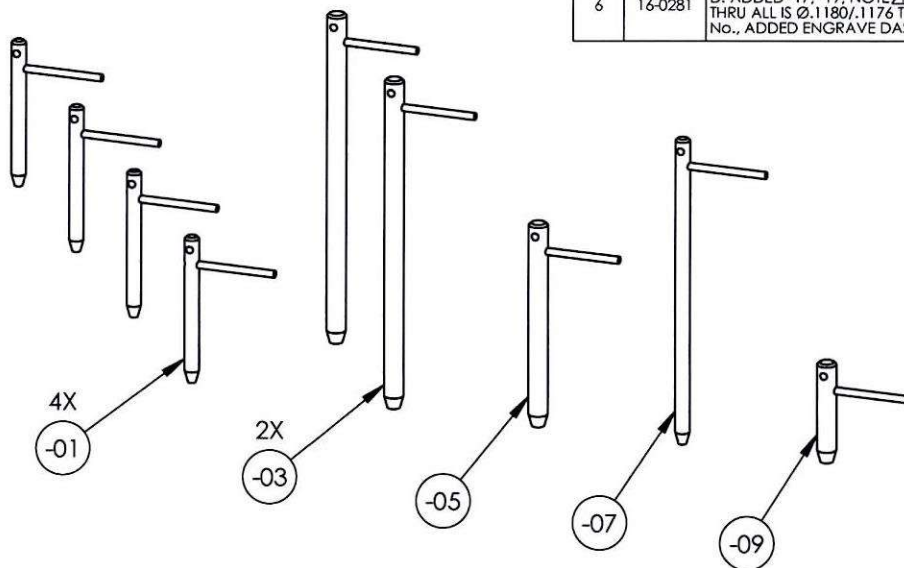


ENGRAVE	PIN DIMENSION TABLE		
DASH No.	P/N	ØA	LENGTH B
-01	-01A	6mm	2.028
-03	-03A	8mm	5.177
-05	-05A	8mm	3.012
-07	-07A	6mm	4.783
-09	-09A	8mm	1.240

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01A	REV 6
MAT'L O-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -01, -03, -05, -07, -09	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 9/11/2009 SHEET 3 OF 3

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/11/2009	WP	DW
2		ADDED ONE MORE -03 PIN, FLAG AND CABLE TIE.	6/14/2010	WP	DW
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -01 THRU -09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	12/15/2010	RJC	RW
4		CORRECTED PIN VIEW SHEET 1 AND CH'D Ø.113 [Ø2.9mm] HOLE TO Ø.118 [Ø3.0mm] PER G.E.	5/9/2012	RJC	GE
4A		CH'D T/N WAS RBEA94-2706-00 IS RBE350A94-2706-00.	11/6/2013	RJC	RW
5	15-0120	UPDATED TO NEW DRAFTING STANDARDS. CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005. ADDED P/N'S -01A, -03A, -05A, -07A, -09A. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/26/2015	DPD	JAG
6	16-0281	UPDATED TO DRAFTING STANDARD. -01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19; NOTE Δ, -01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 ±.001/-0.000 THRU ALL IS Ø.1180/1.176 THRU ALL (P.F.-11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



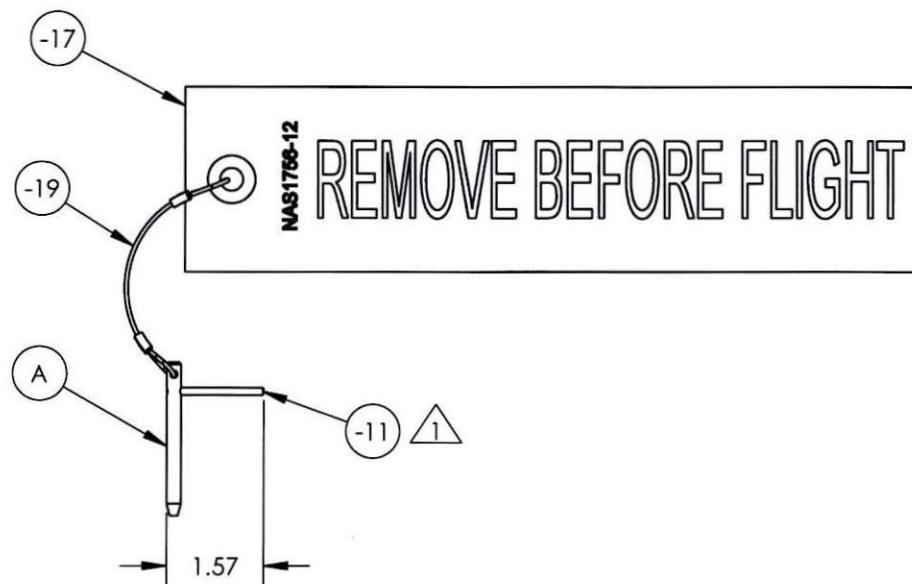
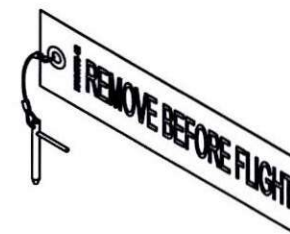
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ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-01	4	PIN			2
				1		-01A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMASTER-CARR #88625K65) MODIFIED	3
			X			-03	2	PIN			2
			1			-03A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
		X				-05	1	PIN			2
		1				-05A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
	X					-07	1	PIN			2
	1					-07A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMASTER-CARR #88625K65) MODIFIED	3
X						-09	1	PIN			2
1						-09A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
1	1	1	1	1	B/O	-11		DOWEL PIN	STEEL	Ø3mm X 40mm (MCMASTER-CARR #91595A142)	2
					B/O	-13	1	RE-SEALABLE PLASTIC BAG		5 IN X 6 IN APPROX.	N/S
A/R	A/R	A/R	A/R	A/R	B/O	-15		LOCTITE 680			2
1	1	1	1	1	B/O	-17		FLAGS, REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
1	1	1	1	1	B/O	-19		CABLE TIE	BLACK NYLON	(MCMASTER-CARR #7189K31)	2
ASSY -09	ASSY -07	ASSY -05	ASSY -03	ASSY -01							

		TITLE	
		RIGGING PIN SET	
DWG NO.		RBE350A94-2706-00	
REV		6	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		PERRITT	
CHECKED:		DUEFELDT	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:3	
DATE		9/11/2009	
SHEET		1 OF 3	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
6	16-0281	-01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE Δ.			1/12/2017	RJC	JAG



ASSY P/N	A P/N
-01	-01A
-03	-03A
-05	-05A
-07	-07A
-09	-09A

NOTE:

1 USE LOCTITE 680 TO ASSEMBLE.

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-01, -03, -05, -07, -09

PIN

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01	REV 6
MAT'L HEAT TREAT FINISH SPEC DRAWN BY: CHECKED: OPPS APPR: QA APPR: APPROVED:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EUROCOPTER AS350/355
QMSI-6.2.2, B.O. REV D PERRITT DUERFELDT ANDERSON LINDSAY GILBERT	SCALE 1:3 DATE 9/11/2009 SHEET 2 OF 3

